

Date: Thursday, 5/11/2006 11:52:10 AM
 User: Kim Johnston

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|--|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | SADDLE FITTING, FWD (OUTBOARD/INBOARD) |
| Job Number : | 27057 | Part Number : | D2572 |
| Estimate Number : | 10531 | Drawing Number : | D2572 REV E |
| P.O. Number : | N/A | Project Number : | N/A |
| This Issue : | 5/11/2006 | Drawing Revision : | E |
| Prsht Rev. : | NC | Material : | N/A |
| First Issue : | N/A | Due Date : | 5/30/2006 |
| Previous Run : | 26973 | Qty: | 12 |
| Written By : | <i>See Comment Below</i> | | |
| Checked & Approved By : | <i>06.05.11</i> | | |
| Comment : | Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|-------------------------|
| 1.0 | D6101005 | 7075-T7351 8.25X5.0X2.5 |
|-----|----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: _____

B24069 x 12 Ep 06/05/15

12

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|

**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. *27057* Double check by: *J.G*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

Ep 06/05/15
J.G

06/05/16

12

| | | |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|

**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

Ep 06/05/15
J.G

06/05/16

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/11/2006 11:52:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27057

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Enobla 19
S.G

06/05/16

12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf

06/05/23

12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06:05:24

12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06/05/24

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PU

6/5/24

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51479*

DA

06/05/24

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD

06/05/25

(12)

Job Completion



C 206/05/25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

| | | | |
|---|--|---------------------|-------|
| DART AEROSPACE LTD | | Work Order: | 27057 |
| Description: Saddle, Fwd Inboard | | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.749 | 1.748 | 1.749 | 1.745 | | |
| C | 3.495 | 3.505 | | 3.499 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.748 | 1.749 | 1.745 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.004 | 8.003 | 8.003 | | |
| F | 0.490 | 0.510 | | 0.501 | 0.502 | 0.501 | 0.497 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.258 | 0.258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8684 | 0.376 | 0.376 | 0.376 | 0.376 | | |
| I | 0.490 | 0.510 | | 0.502 | 0.501 | 0.502 | 0.496 | | |
| J | 1.174 | 1.184 | | 1.188 | 1.180 | 1.180 | 1.178 | | |
| K | 0.558 | 0.578 | | 0.569 | 0.568 | 0.567 | 0.566 | | |
| L | 1.174 | 1.184 | | 1.180 | 1.179 | 1.179 | 1.178 | | |
| M | 1.490 | 1.500 | | 1.494 | 1.498 | 1.497 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.499 | 2.497 | 2.496 | 2.499 | | |
| O | 3.869 | 3.879 | | 3.872 | 3.871 | 3.872 | 3.871 | | |
| P | 0.115 | 0.135 | | 0.121 | 0.120 | 0.119 | 0.121 | | |
| Q | 0.115 | 0.135 | | 0.125 | 0.124 | 0.125 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.250 | 0.249 | 0.248 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.121 | 0.119 | 0.119 | 0.123 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.962 | 2.961 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.241 | 0.242 | 0.241 | 0.239 | | |
| W | 0.115 | 0.135 | | 0.126 | 0.127 | 0.126 | 0.124 | | |
| X | 0.307 | 0.312 | | 0.311 | 0.312 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.364 | 0.365 | 0.362 | 0.362 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.633 | 0.630 | 0.629 | 0.622 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.249 | 0.247 | 0.247 | 0.244 | | |
| AE | 1.375 | 1.395 | | 1.387 | 1.387 | 1.384 | 1.385 | | |
| AF | 0.115 | 0.135 | | 0.132 | 0.130 | 0.130 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.244 | 0.247 | 0.246 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.251 | 0.250 | 0.251 | 0.245 | | |
| AI | 2.000 | 2.020 | | N/A | N/A | N/A | N/A | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|---------------------|
| Measured by: | J.G. / En |
| Date: | 06/05/17 / 06/05/18 |

| | |
|-------------|----------|
| Audited by: | Tm |
| Date: | 06/05/23 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 27057 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.446 | | |
| B | 1.745 | 1.755 | | 1.748 | 1.745 | 1.748 | 1.746 | | |
| C | 3.495 | 3.505 | | 3.496 | 3.499 | 3.496 | 3.496 | | |
| D | 1.745 | 1.755 | | 1.748 | 1.745 | 1.748 | 1.746 | | |
| E | 7.990 | 8.010 | | 8.003 | 8.000 | 8.002 | 8.003 | | |
| F | 0.490 | 0.510 | | 0.497 | 0.497 | 0.498 | 0.497 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.258 | 0.258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8684 | 0.376 | 0.376 | 0.376 | 0.376 | | |
| I | 0.490 | 0.510 | | 0.493 | 0.494 | 0.499 | 0.499 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.175 | 1.178 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.563 | 0.562 | 0.565 | 0.569 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.175 | 1.178 | 1.178 | | |
| M | 1.490 | 1.500 | | 1.492 | 1.494 | 1.493 | 1.493 | | |
| N | 2.495 | 2.505 | | 2.495 | 2.497 | 2.495 | 2.496 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.873 | 3.872 | | |
| P | 0.115 | 0.135 | | 0.125 | 0.124 | 0.123 | 0.124 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.250 | 0.250 | 0.248 | 0.250 | | |
| S | 0.115 | 0.135 | | 0.125 | 0.122 | 0.124 | 0.124 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.966 | 2.966 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.232 | 0.238 | 0.233 | 0.239 | | |
| W | 0.115 | 0.135 | | 0.122 | 0.124 | 0.118 | 0.118 | | |
| X | 0.307 | 0.312 | | 0.311 | 0.311 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.365 | 0.368 | 0.366 | 0.358 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.623 | 0.625 | 0.624 | 0.624 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.244 | 0.242 | 0.240 | 0.243 | | |
| AE | 1.375 | 1.395 | | 1.385 | 1.385 | 1.386 | 1.386 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.242 | 0.251 | 0.248 | 0.248 | | |
| AI | 2.000 | 2.020 | | N/A | N/A | N/A | N/A | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|-------------------|
| Measured by: | S. G. / En |
| Date: | 06/05/17 |

| | |
|-------------|-----------------|
| Audited by: | En |
| Date: | 06/05/17 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | |
|---|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27056 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

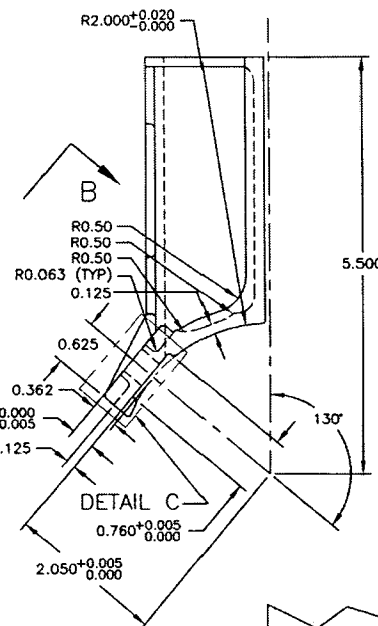
| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.441 | 0.441 | 0.441 | 0.441 | | |
| B | 1.745 | 1.755 | | 1.745 | 1.748 | 1.745 | 1.745 | | |
| C | 3.495 | 3.505 | | 3.498 | 3.499 | 3.498 | 3.499 | | |
| D | 1.745 | 1.755 | | 1.745 | 1.748 | 1.745 | 1.745 | | |
| E | 7.990 | 8.010 | | 8.000 | 8.001 | 8.004 | 8.002 | | |
| F | 0.490 | 0.510 | | 0.497 | 0.494 | 0.493 | 0.494 | | |
| G | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.495 | 0.498 | 0.497 | 0.496 | | |
| J | 1.174 | 1.184 | | 1.175 | 1.178 | 1.177 | 1.176 | | |
| K | 0.558 | 0.578 | | 0.566 | 0.564 | 0.567 | 0.566 | | |
| L | 1.174 | 1.184 | | 1.175 | 1.178 | 1.177 | 1.176 | | |
| M | 1.490 | 1.500 | | 1.497 | 1.493 | 1.493 | 1.494 | | |
| N | 2.495 | 2.505 | | 2.497 | 2.498 | 2.500 | 2.495 | | |
| O | 3.869 | 3.879 | | 3.873 | 3.873 | 3.871 | 3.872 | | |
| P | 0.115 | 0.135 | | 0.126 | 0.127 | 0.124 | 0.124 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.250 | 0.246 | 0.249 | 0.250 | | |
| S | 0.115 | 0.135 | | 0.126 | 0.123 | 0.123 | 0.123 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.189 | 0.189 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.235 | 0.239 | 0.237 | 0.237 | | |
| W | 0.115 | 0.135 | | 0.122 | 0.122 | 0.121 | 0.122 | | |
| X | 0.307 | 0.312 | | 0.311 | 0.310 | 0.311 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.370 | 0.365 | 0.363 | 0.366 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.502 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.623 | 0.626 | 0.625 | 0.622 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.257 | 0.246 | 0.241 | 0.241 | | |
| AE | 1.375 | 1.395 | | 1.388 | 1.382 | 1.385 | 1.385 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.248 | 0.246 | 0.246 | 0.246 | | |
| AI | 2.000 | 2.020 | | N/A | N/A | N/A | N/A | | |
| AJ | 0.023 | 0.043 | | 0.030 | 0.030 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | Ed |
| Date: | 06/05/19 |

| | |
|-------------|----------|
| Audited by: | Jml |
| Date: | 06/05/23 |

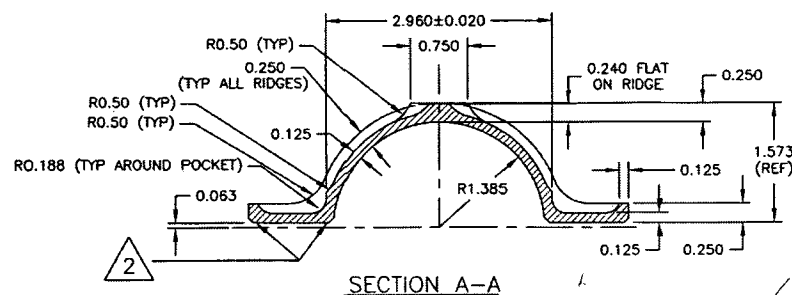
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



VIEW B-B

R0.66 (TYP)

R0.50 (TYP)

1.750 ± 0.005




3.500 ± 0.005

1.750 ± 0.005

8.000

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

| | | |
|---|--|--|
| E | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |
| DESIGN | | |
| DS | DRAWN BY: PH | |
|  | | DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA |
| CHECKED  | APPROVED  | REV. |
| DRAWING NO. D2572 | | SHEET 1 OF |
| DATE 05.07.13 | TITLE INNER FWD SADDLE | |
| | SCALE | |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27057